

**Work Order ID 85578**

Monday, June 11, 2012 11:17:47 AM

**\*85578\****Ship mesd* Page 1

Item ID: E4662-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Pilot Panel

Stop **\*NS2\***

Start Date: 6/11/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 6/12/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *12-06-11*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
E4662	A								
100		0.00							
<b>*100*</b>	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
<i>2024 .125"</i>	Dwg Rev: <i>A</i>								
<i>6061</i>	Prog Rev: <i>A</i>								
	2- Deburr if necessary								
110		0.00							
<b>*110*</b>	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

*1 0 Jm 12-6-11**1 0 Jm 12-6-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85578

Monday, June 11, 2012 11:17:47 AM

**\*85578\***

Page 2

Item ID: E4662-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Pilot Panel  
 Start Date: 6/11/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 6/12/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00							
130 <b>*130*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00							
140 <b>*140*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00 0.00							

8/16/11

100

1 CF 12-6-11

IX

12/06/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 85578****\*85578\***

Page 3

Item ID: E4662-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Pilot Panel

Stop **\*NS2\***

Start Date: 6/11/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 6/12/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: *shop*

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

*12-06-12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 11, 2012 11:17:46 AM

Page 1

Work Order ID: 85578

Parent Item: E4662-3

Parent Item Name: Pilot Panel

Start Date: 6/11/2012

Required Date: 6/12/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.06.04 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.125

Purchased

No

100

sf

58.0945

2.3344

2.4572632

6061-T6 .125 Sheet

Jm 12-6-11

Location

Loc Qty

Loc Code

MAT021

58.0945

121473

58.0945

121473

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

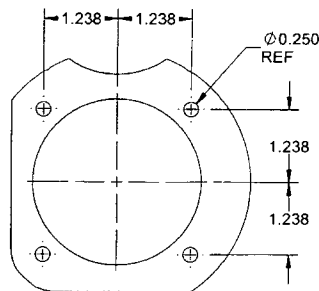
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

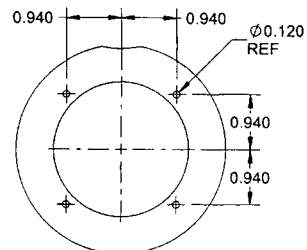
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

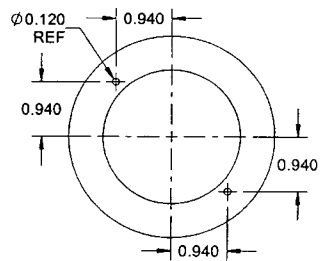




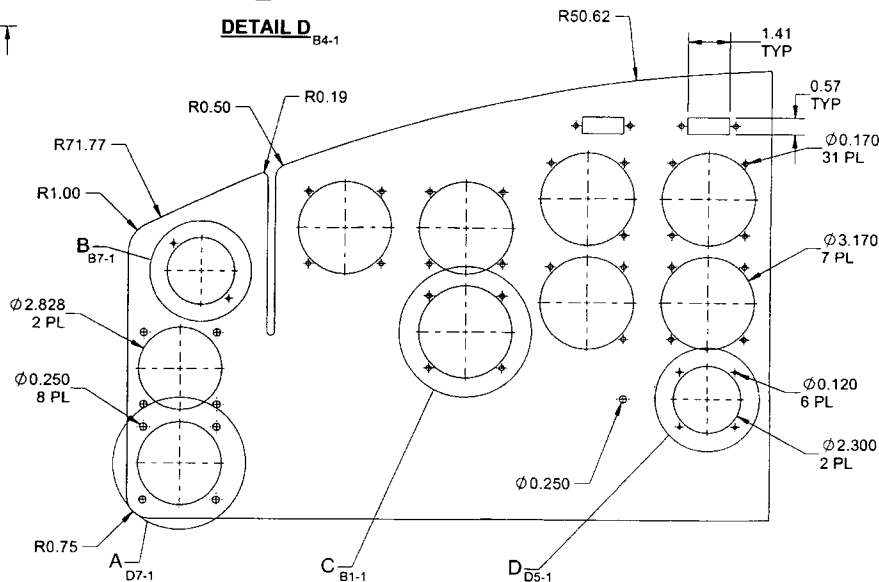
**DETAIL A**  
B6-1



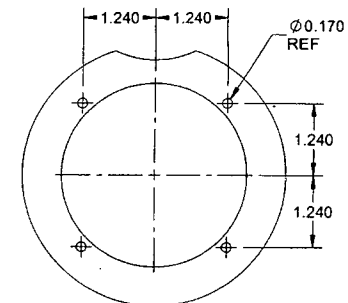
**DETAIL D**  
B4-1



**DETAIL B**  
C6-1



**E4662-1 CO-PILOT PANEL**



**DETAIL C**  
B5-1

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.125 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.125  
OR  
6061-T6/T62 ALUMINUM SHEET, 0.125 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 2.60 lbs

A		NEW ISSUE		DC		12.05.28	
REV.		DESCRIPTION		BY	DATE		
DESIGN	AB	<b>EAGLE COPTERS LTD</b> CALGARY, ALBERTA, CANADA		REV. A		SHEET 1 OF 4	
DRAWN	BC						
CHECKED	AB	DRAWING NO.		E4662			
MFG. APPR.	BE	TITLE		INSTRUMENT PANEL		SCALE	
APPROVED	AB					NTS	
DE APPR.	N/A						
DATE	12.05.28						

**RELEASED**  
2012-06-08  
MD

8576

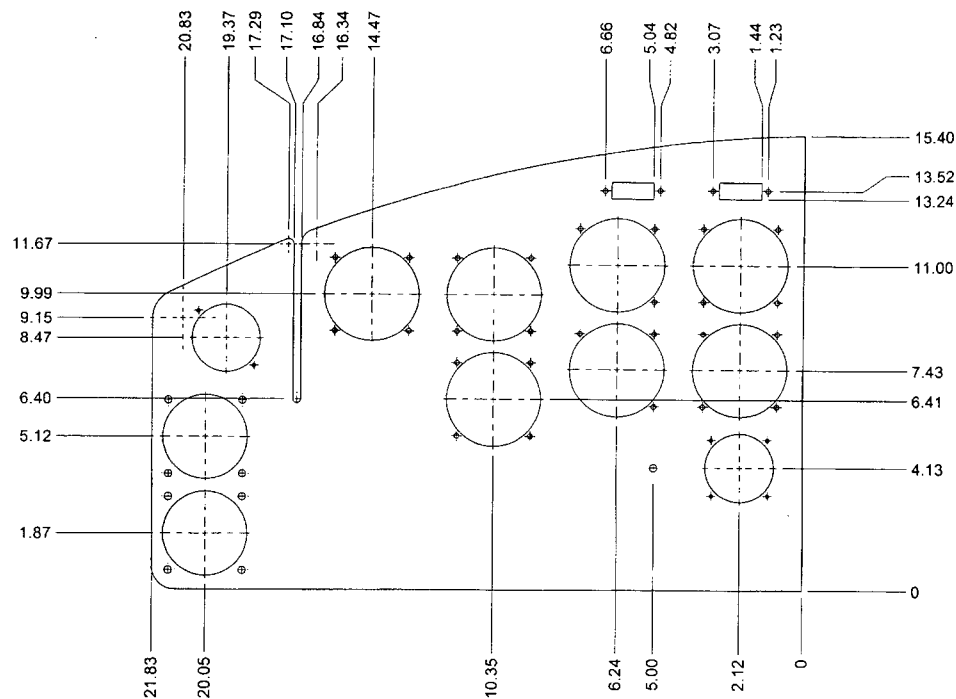
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**E4662-1 CO-PILOT PANEL**  
AUXILIARY VIEW

**RELEASED**  
2012-06-01

DESIGN	BE	<b>EAGLE COPTERS LTD</b>	
DRAWN	BC	CALGARY, ALBERTA, CANADA	
CHECKED	BE	DRAWING NO.	REV. A
MFG. APPR.	BE	E4662	SHEET 2 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	N/A	INSTRUMENT PANEL	NTS
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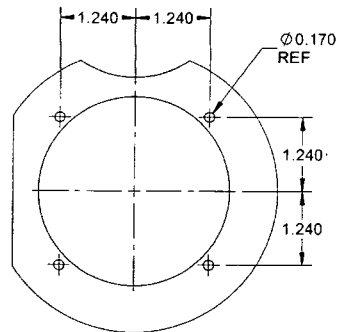
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

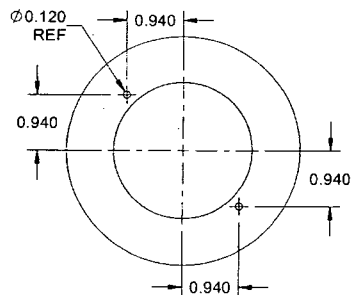
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

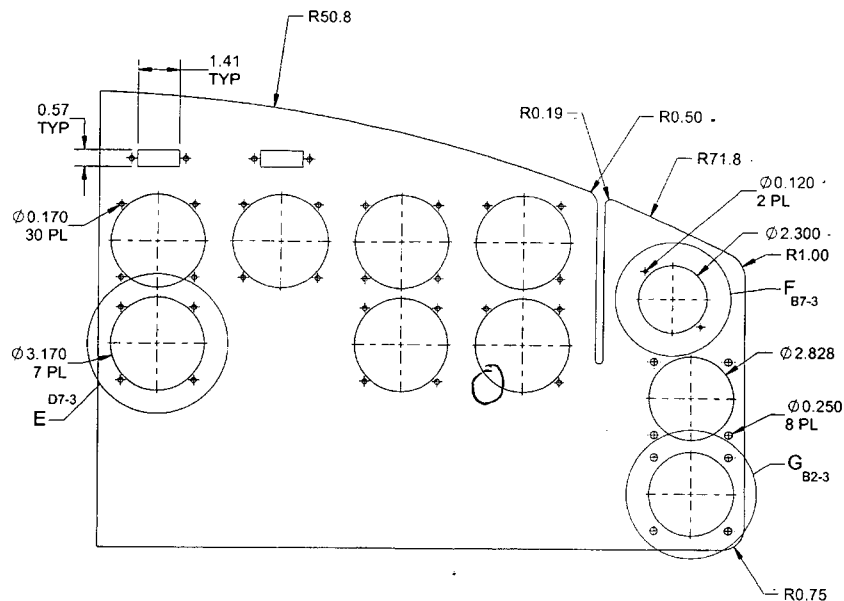


**DETAIL E**  
C5-3

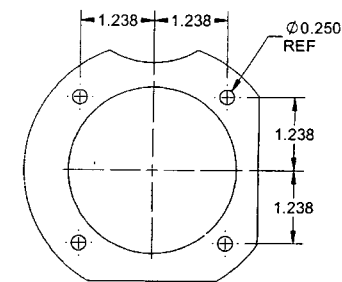
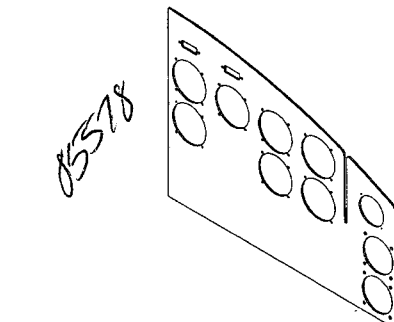


**DETAIL F**  
C3-3

0.125  
REF



**E4662-3 PILOT PANEL**



**DETAIL G**  
B3-3

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.125 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.125  
OR  
6061-T6/T62 ALUMINUM SHEET, 0.125 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 2.63 lbs

**RELEASED**  
R 2012-06-01

DESIGN	BE	<b>EAGLE COPTERS LTD</b>	
DRAWN	BC	CALGARY, ALBERTA, CANADA	
CHECKED	BE	DRAWING NO.	REV. A
MFG. APPR.	BE	E4662	SHEET 3 OF 4
APPROVED	140	TITLE	SCALE
DE APPR.	N/A	<b>INSTRUMENT PANEL</b>	
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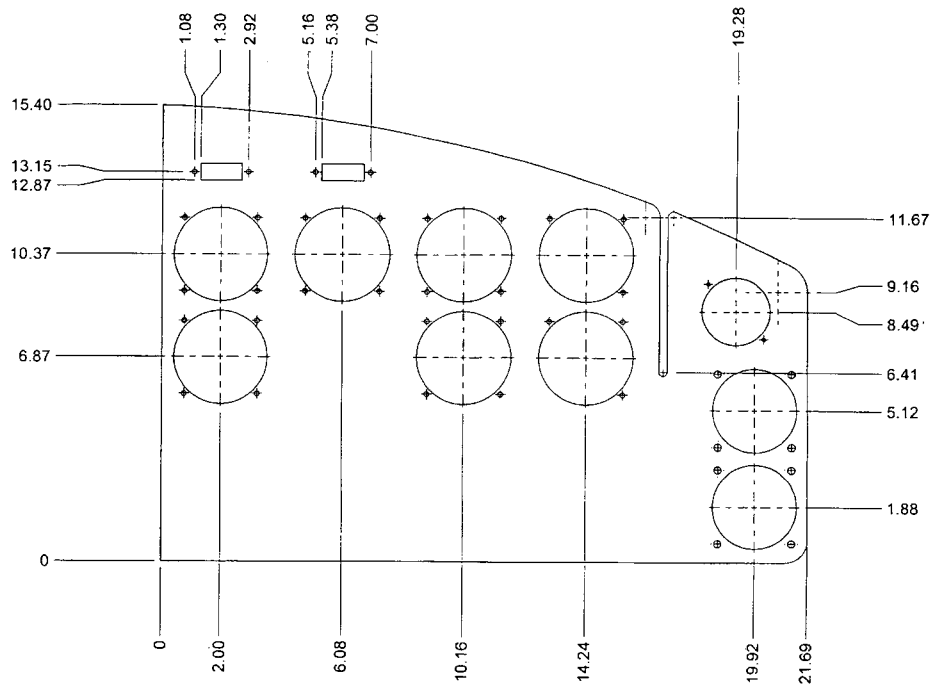
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**E4662-3 PILOT PANEL**  
AUXILIARY VIEW

**RELEASED**  
2012-06-01  
AP

DESIGN	BC	<b>EAGLE COPTERS LTD</b>	
DRAWN	BC	CALGARY, ALBERTA, CANADA	
CHECKED	BC	DRAWING NO.	REV. A
MFG. APPR.	BC	<b>E4662</b>	SHEET 4 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	N/A	<b>INSTRUMENT PANEL</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order: 85378
Description: Pilot Panel		Part Number: ED E4662-3
Inspection Dwg: E4662	Rev: 1	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.240"	+/- 0.010"	1.241"	✓		✓	mm01
1.240"	+/- 0.010"	1.241"	✓		✓	mm01
Ø 1.70 0.130"	+0.005 -0.001"	0.171"	✓		✓	mm01
1.240"	+/- 0.010"	1.243"	✓		✓	mm01
1.240"	+/- 0.010"	1.243"	✓		✓	mm01
Ø 0.120"	+0.005 -0.001"	0.120"	✓		✓	mm01
0.940"	+/- 0.010"	0.941"	✓		✓	mm01
0.940"	+/- 0.010"	0.942"	✓		✓	mm01
0.940"	+/- 0.010"	0.940"	✓		✓	mm01
0.940"	+/- 0.010"	0.941"	✓		✓	mm01
0.125"	+/- 0.010"	0.126"	✓		✓	mm01
0.57"	+/- 0.030"	0.562"	✓		✓	mm01
Ø 0.170"	+0.005 -0.001"	0.172"	✓		✓	mm01
Ø 3.170"	+0.012 -0.001"	3.170"	✓		✓	mm01
1.41"	+/- 0.030"	1.405"	✓		✓	mm01
R 50.8"	+/- 0.030 +/- 0.000	50.8"	✓			
R 0.19"	+/- 0.030	0.19"	✓		RG	
R 0.50"	+/- 0.030	0.50"	✓		RG	
R 71.8"	+/- 0.100	71.8"	✓			
Ø 0.120"	+0.005 -0.001"	0.120"	✓		✓	mm01
Ø 2.300"	+0.012 -0.001"	Ø 2.292"	✓		✓	mm01
Ø 2.828"	+0.012 -0.001"	Ø 2.828"	✓		✓	mm01
Ø 0.250"	+0.005 -0.001"	Ø 0.251"	✓		✓	mm01

Measured by: Jm	Audited by: S	Preliminary Approval:
Date: 12-6-11	Date: 12/09/11	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 85378
<b>Description:</b> Pilot Panel		<b>Part Number:</b> F4662-3
<b>Inspection Dwg:</b> F4662 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R 0.75"	+/- 0.030	0.75"	✓		RG	
1.238"	+/- 0.010	1.239"	✓		✓	mmoi
1.238"	+/- 0.010	1.240"	✓		✓	mmoi
Ø 0.250"	+/- 0.005	0.251"	✓		✓	mmoi
1.238"	+/- 0.010	1.239"	✓		✓	mmoi
1.238"	+/- 0.010	1.239"	✓		✓	mmoi
15.40"	+/- 0.030	15.40"	✓		MT	H-B-01
13.15"	+/- 0.030	13.15"	✓		MT	H-B-01
12.87"	+/- 0.030	12.87"	✓		MT	H-B-01
10.37"	+/- 0.030	10.37"	✓		MT ✓	Production
6.87"	+/- 0.030	6.892"	✓		✓	mmoi
2.00"	+/- 0.030	2.009"	✓		✓	mmoi
6.08"	+/- 0.030	6.092"	✓		✓	mmoi
10.16"	+/- 0.030	10.175"	✓		✓	mmoi
14.24"	+/- 0.030	14.24"	✓		MT	H-B-01
19.92"	+/- 0.030	19.92"	✓		MT	H-B-01
21.69"	+/- 0.030	21.69"	✓		MT	H-B-01
1.88"	+/- 0.030	1.891"	✓		✓	mmoi
5.12"	+/- 0.030	5.131"	✓		✓	mmoi
6.41"	+/- 0.030	6.399"	✓		✓	mmoi
8.49"	+/- 0.030	8.495"	✓		✓	mmoi
9.16"	+/- 0.030	9.165"	✓		✓	mmoi
11.67"	+/- 0.030	11.679"	✓		✓	mmoi

<b>Measured by:</b>	JM
<b>Date:</b>	12-10-11

<b>Audited by:</b>	S
<b>Date:</b>	12/6/11

<b>Preliminary Approval:</b>	
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

## FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	JM	Audited by:	S	Preliminary Approval:	
Date:	12-6-11	Date:	12/6/11	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	